

Work Order ID 135670

Monday, August 17, 2015 7:20:20 AM

135670

BLUE

Page 1

Item ID: D206-642-341

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube (Fits LH or RH)

Stop *NS2*

Start Date: 8/14/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLS Date: AUG 17 2015 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2650	F(DEO)

100	Document Control	0.00
-----	------------------	------

100

DC	DOCUMENT CONTROL	0.00
----	------------------	------

Doc.Control -USB or Paperwork

Memo Photocopy bluefile and create labels per PPP D206-642-341 CHG005

N/A MLS SEP 29 2015

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Item Name: Replacement Skidtube (Fits LH or RH)

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Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.02

Skidtubes

Memo

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/RAluminum Rod MB1562

4-Grind weld flush to cap on top surface only.

5-Cut aft end to lenght as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11- Ream holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

12-Deburr.

> DGL 15-8-19.

> BE15-08-20

> DGL 15-8-24.

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Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115 *115* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				①			DAS 38 9-89 AUG 25 2015
116 *116* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				①	15-08-25		DAS 9 9-89
120 *120* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.01				1	①	15-8-25	JH

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Stop ***NS2***Start Date: 8/14/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	QC7-Inspect Chemical Conversion Coat	0.00							
125									
QC	Memo	0.00							
Quality Control									
									15-8-26 DGC
130		0.00							
130									
Skidtubes									
Skidtubes	Memo	0.01							
	1- Bond D2654-5 web in place as per QSI 015 Ensure holes line upAllow 12 Hrs. cure time before cutting Start Date: _____ Time: _____ Finish Date: _____ Time: _____ A/RSikaflex-291 132705 Sikaflex expiry date: 15-8-26								
									15-8-26 Day J
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
									15-8-27

DAS
03
9-09

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Accept

N900040100Setup Start ***NS1***

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Item Name: Replacement Skidtube (Fits LH or RH)

Stop ***NS2***Start Date: 8/14/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Skidtubes								
Skidtubes	Memo	0.02							
Skidtubes	1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002								
	2- Install nut plate as per dwg								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
190	Pressure Wash per QSI005 4.3	0.00							
190									
HandFinish	Memo	0.01							
Hand Finishing									

DAS
38
3-89
AUG 27 2015

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Item ID: D206-642-341

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube (Fits LH or RH)

Stop ***NS2***Start Date: 8/14/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

205

Spray Painting per QSI005 4.2

0.00

205

SprayPaint

Memo

0.00

Spray Painting

TEMPO PRIMER B 132910
DELFLEET BLUE B 132641
DELFLEET CLEAR B 129271

PRIME:

START TIME: 800FINISH TIME: 830

PAINT:

START TIME: 1000FINISH TIME: 1100DAS
41
9-89

15-9-15

206

QC14- Inspect Spray Paint

0.00

206

QC

Memo

0.00

Quality Control

1x d 40 15/09/15 DAS
15
9-89

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Item ID: D206-642-341

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube (Fits LH or RH)

Stop ***NS2***Start Date: 8/14/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
220	HandFinishing								
HandFinish	Memo	0.03							
Hand Finishing	1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/RSikaflex-291 <u>M133122</u> Sikaflex expiry date: <u>1603</u>								
	2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive <u>RTU 598 M131311 16/11</u>								
	3-Install MS27039-4-06 Screw								
	4-Inspect for foreign object per QSI 024								
	5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/RSikaflex-291 <u>M133122</u> Sikaflex expiry date: <u>1603</u>								
	6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 Batch: <u>M133087</u>								

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Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Replacement Skidtube (Fits LH or RH)

Stop

NS2

Start Date: 8/14/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00							
230								DAS	
QC	Memo	0.00				0	15-09-29	9	
Quality Control								9-89	
240	QC5- Inspect part completeness to step on W/O	0.00							
240								DAS	
QC	Memo	0.00				0	15-09-29	9	
Quality Control								9-89	
250	Packaging	0.00							
250									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-341 Location:FG083								

RD 135655

68-8
9
9-89

SEP 29 2015

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Item ID: D206-642-341 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Skidtube (Fits LH or RH)
Start Date: 8/14/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/14/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC21- Final Inspection - Work Order Release	0.00							
260									
QC	Memo	0.00							
Quality Control									

MLJ SEP 29 2015

HS 9.29

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135670

D206-642-341

Start Date: 8/14/2015**Required Date:** 8/14/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-03-02 as per DSI9440 rev.a DD verified by:EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verf:DD IPP Rev:L 12.11.22 now swage per ecn12-679 DD verf:JLM IPP Rev:M 14.04.25 ECN14-520 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CCR264SS3-3 *CCR264SS3-3* Cherry Rivet	CCR264SS-3-03	Purchased	No				Each	0.0000		2			
CR3212-4-03 *CR3212-4-03* Cherry Rivet		Purchased	No				Each	500.0000		2			
					<u>Location</u>	<u>Loc Qty</u>			<u>Loc Code</u>				
					CCK004	500							
					119017	500							
D2620 *D2620* Skidtube, 206 Skidtube		Manufactured	No				Each	5.0000		1			
					<u>Location</u>	<u>Loc Qty</u>			<u>Loc Code</u>				
					LG002	5							
					126930	1							
					135311	4							
D2647 *D2647* Cap		Manufactured	No				Each	0.0000		1			

Picklist Print

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Work Order ID: 135670

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Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 8/14/2015

Required Date: 8/14/2015

Start Qty: 1.00

Required Qty: 1.00

D2654-5

Manufactured No

Each

5.0000

1

D2654-5

Web

135935 x1 Doc 15-8-26

Location

Loc Qty

Loc Code

LG002

5

132476

1

134835

4

D2680-041

Manufactured No

Each

17.0000

1

D2680-041

Nut Plate

Location

Loc Qty

Loc Code

LG

17

129083

17

D4956-11

Manufactured No

Each

6.0000

1

D4956-11

Wearplate Fwd

2 Doc 15-8-27

13/09/16

Location

Loc Qty

Loc Code

FP002

6

127081

6

D4956-23

Manufactured No

Each

11.0000

1

D4956-23

Wearplate Center Fwd

X1

13/09/16

Location

Loc Qty

Loc Code

FP002

11

133386

5

133904

6

X1

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Work Order ID: 135670

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Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 8/14/2015

Required Date: 8/14/2015

Start Qty: 1.00

Required Qty: 1.00

D4956-35 Manufactured No

Each 15.0000 1

D4956-35

Wearplate Aft

lll 15/08/15

Location

Loc Qty

Loc Code

FP002

15

133525

2

134219

13

Each

753.0000

2

lll 15/08/15

MS27039-1-08

Purchased No

MS27039-1-08

Screw

Location

Loc Qty

Loc Code

CA

96

m128636

96

FP001

365

m128636

365

GA

2

125654

2

ST285

290

m128636

290

Each

627.0000

54

lll 15/08/15

MS27039C1-08

Purchased No

MS27039C1-08

SCREW

Location

Loc Qty

Loc Code

ST273A

606

m132256

106

m132317

500

ST283

21

126284

21

M133064

154

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Work Order ID: 135670

135670

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 8/14/2015

Required Date: 8/14/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

3,042.000

1

NAS1149D0463J

WASHER

all skid tubes

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M132677

1000

ST269

2001

M127904

20

M129682

86

M130799

371

M132035

1399

M132317

125

X1

D4720-1

Manufactured

No

150

Each

150.0000

19

19

D4720-1

Spacer

Location

Loc Qty

Loc Code

LG001

150

129566

150

220

Each

1,591.000

54

54

ALS4-1032-130

AEALS4-1032-130 Purchased

No

ALS4-1032-130

Rivnut

Doc - 15-8-27.

all skid tubes

Location

Loc Qty

Loc Code

st549

1591

M132317

391

M132954

1200

M133077

X54

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Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 8/14/2015

Required Date: 8/14/2015

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

220

Each

55.0000

1

1

D2646

Aft Cap

**

ll 13/08/16

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

51

103306

1

114495

1

127924

4

128761

1

132325

16

132326

28

X1

BLUE

D2651-1

Manufactured No

220

Each

168.0000

14

14

D2651-1

Plug

**

ll 13/08/16

Location

Loc Qty

Loc Code

FP001

168

131695

30

132398

18

134571

120

B135636

X14

BLUE

D2651-3

Manufactured No

220

Each

228.0000

14

14

D2651-3

O-Ring

**

ll 13/08/16

Location

Loc Qty

Loc Code

FP001

228

113577

16

120110

212

X14

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Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 8/14/2015

Required Date: 8/14/2015

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

220

Each

72.0000

6

6

D3537-1

Wearpad

ll 15/08/19

Location

Loc Qty

Loc Code

FG

18

B136312

x6

79833

8

88562

10

FP001

45

128225

1

133512

9

134225

35

ST611

9

125911

9

D3537-3

Manufactured No

220

Each

16.0000

1

1

D3537-3

Wearpad

ll 15/08/20

Location

Loc Qty

Loc Code

FG

8

B136886

x6

86237

8

FP001

6

132702

6

ST611

2

120646

2

MS27039-4-06

Purchased No

220

Each

101.0000

1

1

MS27039-4-06

Screw

ll 15/08/16

Location

Loc Qty

Loc Code

FP001

96

m132317

96

ST283

5

m126534

5

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Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 8/14/2015

Required Date: 8/14/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

220

Each

4,955.000

54

54

NAS1149C0332R

WASHER

all 13/08/15

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

x54

GA

221

m131618

221

ST260a

2000

m132930

2000

ST271

594

m129390

72

m132262

522

NAS1149D0332J

Purchased

No

220

Each

2,210.000

2

2

NAS1149D0332.J

Washer

all 13/08/15

Location

Loc Qty

Loc Code

CA

14

m129682

14

GA

622

m132677

622

ST269

1574

m130325

900

m131624

46

m132677

628

x2

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

135670 MLJ
15-08-17

DEO ATTACHED

RELEASED
08-07-23

NOTES:

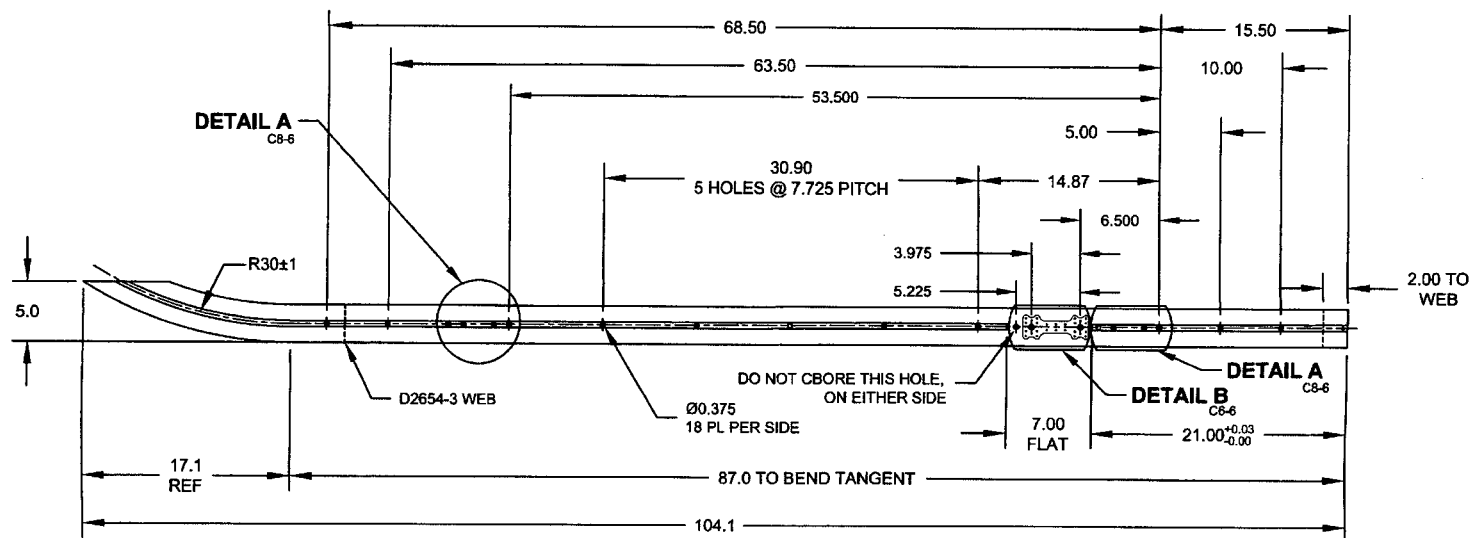
- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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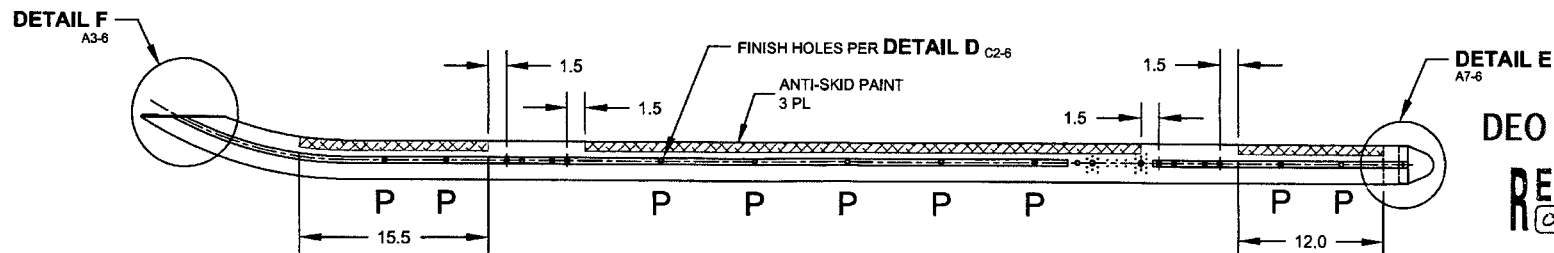


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MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 2 OF 6
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D2650-3 BENDING/DRILLING DETAIL



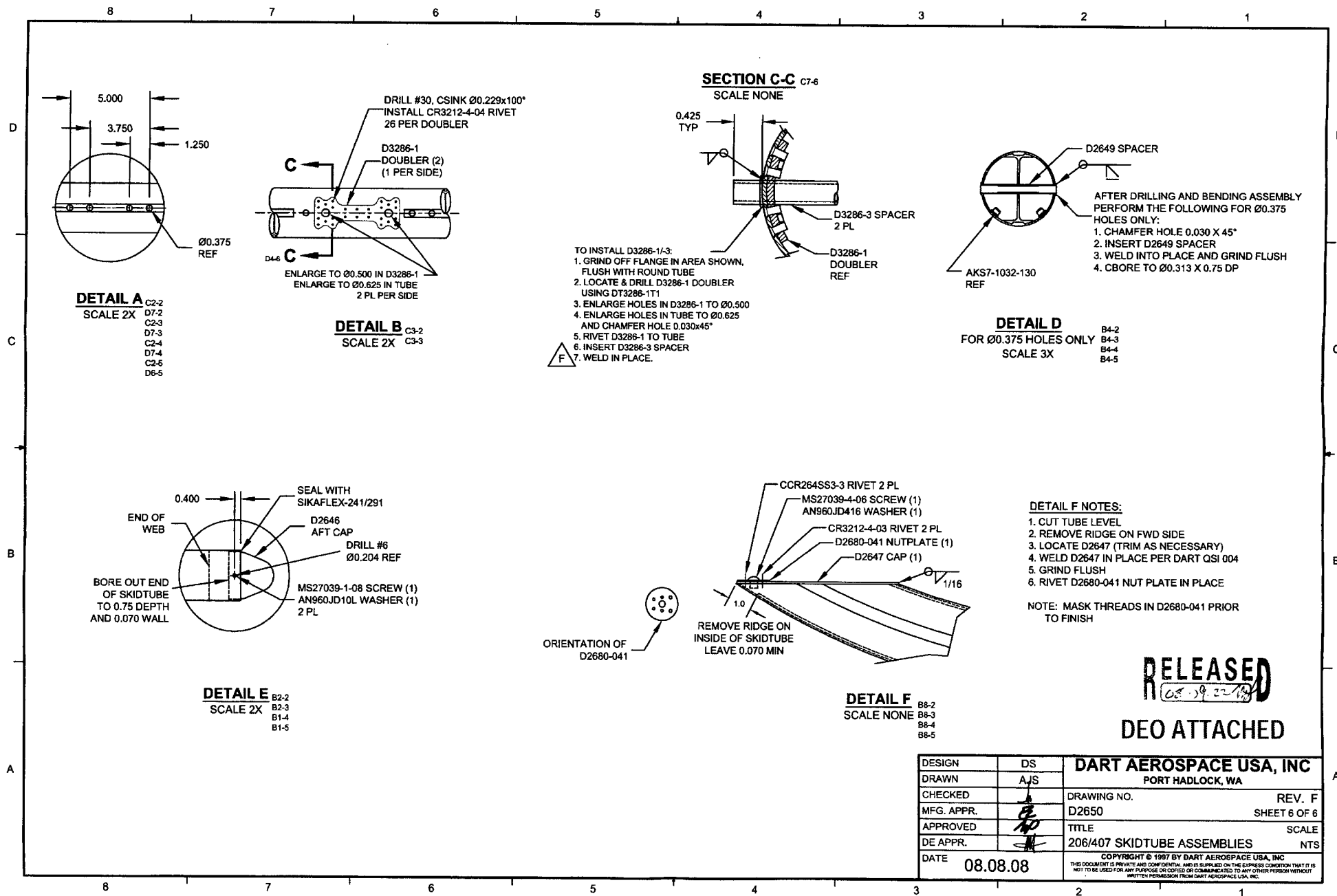
D2650-3 ASSEMBLY/FINISHING DETAIL

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RELEASED
08 07 22-118

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MFG. APPR.		D2650	SHEET 3 OF 6
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MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED A.P.	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

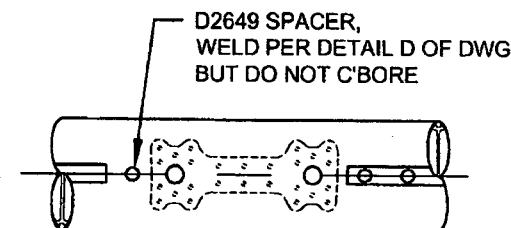
IS:

QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
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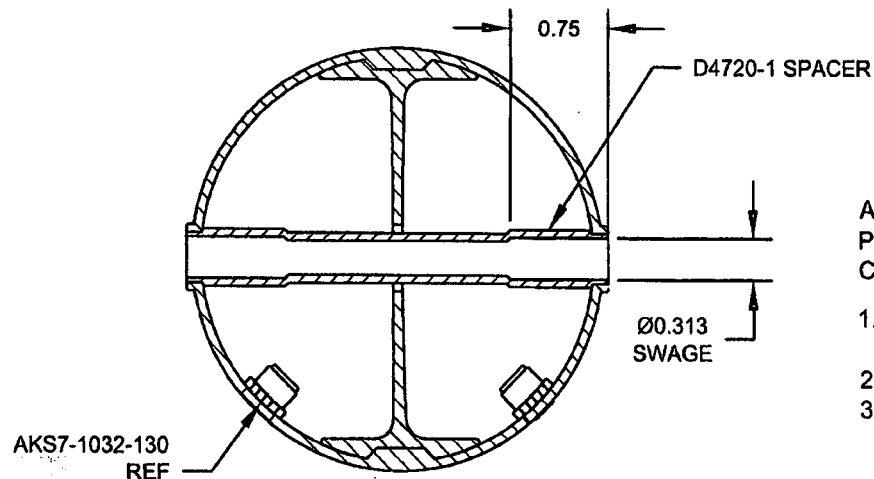
ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.
C'BORED HOLES ARE **NOW SWAGED** PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
[Signature]



DETAIL G

FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3) OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002